Work Order ID 60292

July 1, 2010 11:48:05 AM

Item ID: D3121-144 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Bracket Assembly

Start Date: 02/07/2010 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 29/07/2010 **Req'd Qty:** 4.00 **Customer:**

Reference: 10.07.21

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D3121 / Rev E									
100		0.00							
Bandsaw	BAND SAW					4	Ø		
Jeaspa Bandsaw	**Memo** Cut blanks: (1.250" x 2.000") 4.425" long	0.00	10/07/19						
110		0.00							
HAAS 1	HAAS CNC VERTICAL MACHINING #1		10.7.21			4	Ø		
HAAS CNC vertical machine #1	**Memo** 1-Machine D3121-114 as per Folio FA330 and Dwg D3121 Identify as D3121-114□2-Deburr□3-Scribe batch number	0.00	B.A 10/07/22						
120	QC2- Inspect parts off machine FAI/FAIB	0.00	10.7.21			4	Ø		
QC	**Memo**	0.00							
Quality Control									

Work Order ID 60292

July 1, 2010 11:48:05 AM

Item ID: D3121-144 **Accept** **Setup** **Start** **Stop**

Revision ID:

Item Name: Bracket Assembly

Start Date: 02/07/2010 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 29/07/2010 **Req'd Qty:** 4.00 **Customer:**

Reference:

Run **Start** **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00	10/07/22			4	4		
Quality Control									
140		0.00							
Small Fab	Small Fab								
Small Fab	Memo	0.00					10/07/26		
	Assemble D3121-143 as per Dwg D3121.								
150	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00	10/07/27			4			
Quality Control									

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Item ID: D3121-144 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Bracket Assembly

Start Date: 02/07/2010 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 29/07/2010 **Req'd Qty:** 4.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location 235A	0.00							
Packaging	Memo	0.00				10/7/27		40	
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00					10/07/28		
Quality Control									

pl 10-7-27 4

Picklist Print

July 1, 2010 11:48:04 AM

Work Order ID: 60292

Parent Item: D3121-144

Parent Item Name: Bracket Assembly

Start Date: 02/07/2010 **Required Date:** 29/07/2010

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP Rev:Pick:A□04.02.18□New issue□KJ/DS□
IPP Rev:B ECN 1060 07-11-12 DD verified by:EC
IPP Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-21		Manufactured	No			140	Each	31.0000	2	8			
Bolt													
				Location			**Loc Qty**		**Loc Code**				
				ST235			31						
					57376		1						
					59044		30						
D3121-241		Manufactured	No			100	Each	8.0000	2	8			
Bearing Assembly													
				Location			**Loc Qty**		**Loc Code**				
				ST235B			8						
					55005		2						
					59774		6						
M174B1.250X02.000		Purchased	No			140	f	12.0000	0.368	1.549474			
17-4 SS Bar 1.250 x 2.00													
				Location			**Loc Qty**		**Loc Code**				
				MAT			12						
					114899		12						

10/07/26

8

10/07/26

B59435 (42)

4x

1.5494 ark 10/07/19

DART AEROSPACE LTD	Work Order:	60292
Description: Bracket	Part Number:	D3121-114
Inspection Dwg: D3121 **Rev:** E		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.080	+/-0.010	.078	✓			
0.300	+/-0.010	.301	✓			
R0.375	+/-0.010	R.375	✓			
1.54	+/-0.030	1.54	✓			
0.350	+/-0.010	.350	✓			
R0.25	+/-0.030	R.25	✓			
Ø0.392	+0.002/-0.000	.393	✓			
Ø0.201	+0.005/-0.000	.201	✓			
0.100	+/-0.010	.100	✓			
2.540	+/-0.010	2.537	✓			
1.590	+/-0.010	1.587	✓			
0.160	+/-0.010	.158	✓			
0.400	+/-0.010	.400	✓			
1.220	+/-0.010	1.220	✓			
1.600	+/-0.010	1.605	✓			
3.80	+/-0.030	3.80	✓			
1.800	+/-0.010	1.803	✓			
R0.50	+/-0.030	R.50	✓			
0.130	+/-0.010	.136	✓			
3.41	+/-0.030	3.41	✓			
3.65	+/-0.030	3.638	✓			
2.24	+/-0.030	2.21	✓			
45°	+/-0.1°	45°	✓			
R0.25	+/-0.030	R.25	✓			
3.97	+/-0.030	3.975	✓			
R0.38	+/-0.030	R.38	✓			
Ø0.392	+0.002/-0.000	.393	✓			
Ø0.201	+0.005/-0.000	.201	✓			
0.268	+/-0.010	.268	✓			
R0.260	+/-0.010	R.260	✓			
0.080	+/-0.010	.080	✓			
0.300	+/-0.010	.301	✓			
0.381	+/-0.010	.385	✓			
0.201	+/-0.010	.201	✓			

DART AEROSPACE LTD	Work Order:	60292.
Description: Bracket	Part Number:	D3121-114
Inspection Dwg: D3121 Rev: E		Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.580	+/-0.010	.580	✓			
0.400	+/-0.010	.402	✓			
100°	+/-0.1°	100°	✓			
0.032	+0.000/-0.010	.028	✓			

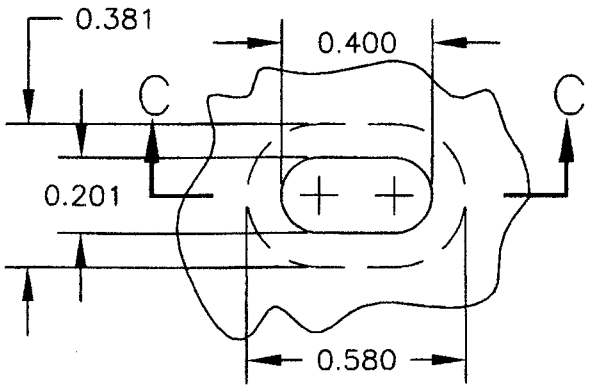
Measured by:		Audited by:		Prototype Approval:	N/A
Date:	10.7.21	Date:	10/07/22	Date:	N/A

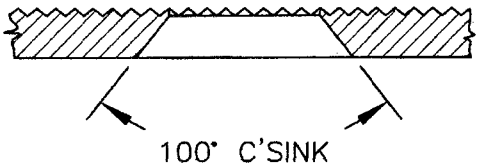
Rev	Date	Change	Revised by	Approved
A	03.12.08	New Issue P/O D3121-144	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	
D	08.01.16	Dimensions updated per Dwg Rev E	KJ/EC/DD	
E	08.05.20	0.032 dimension was 0.32	KJ/DD	

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. E SHEET 3 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

w/o 60292

DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED

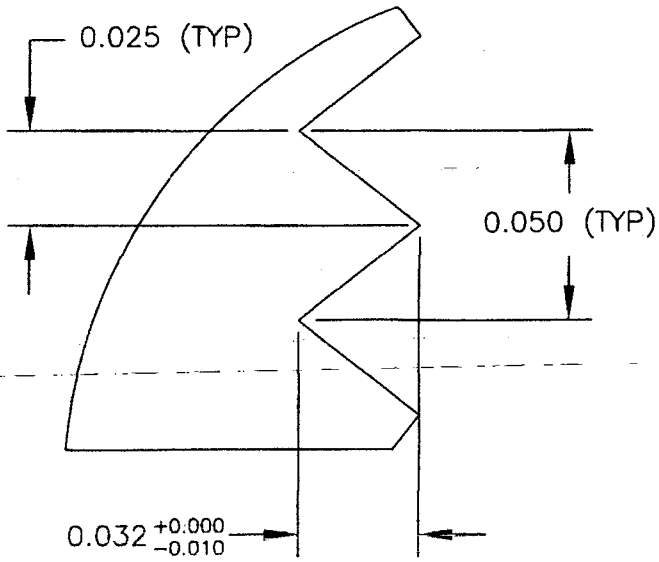




SECTION C–C

RELEASED 07.11.07

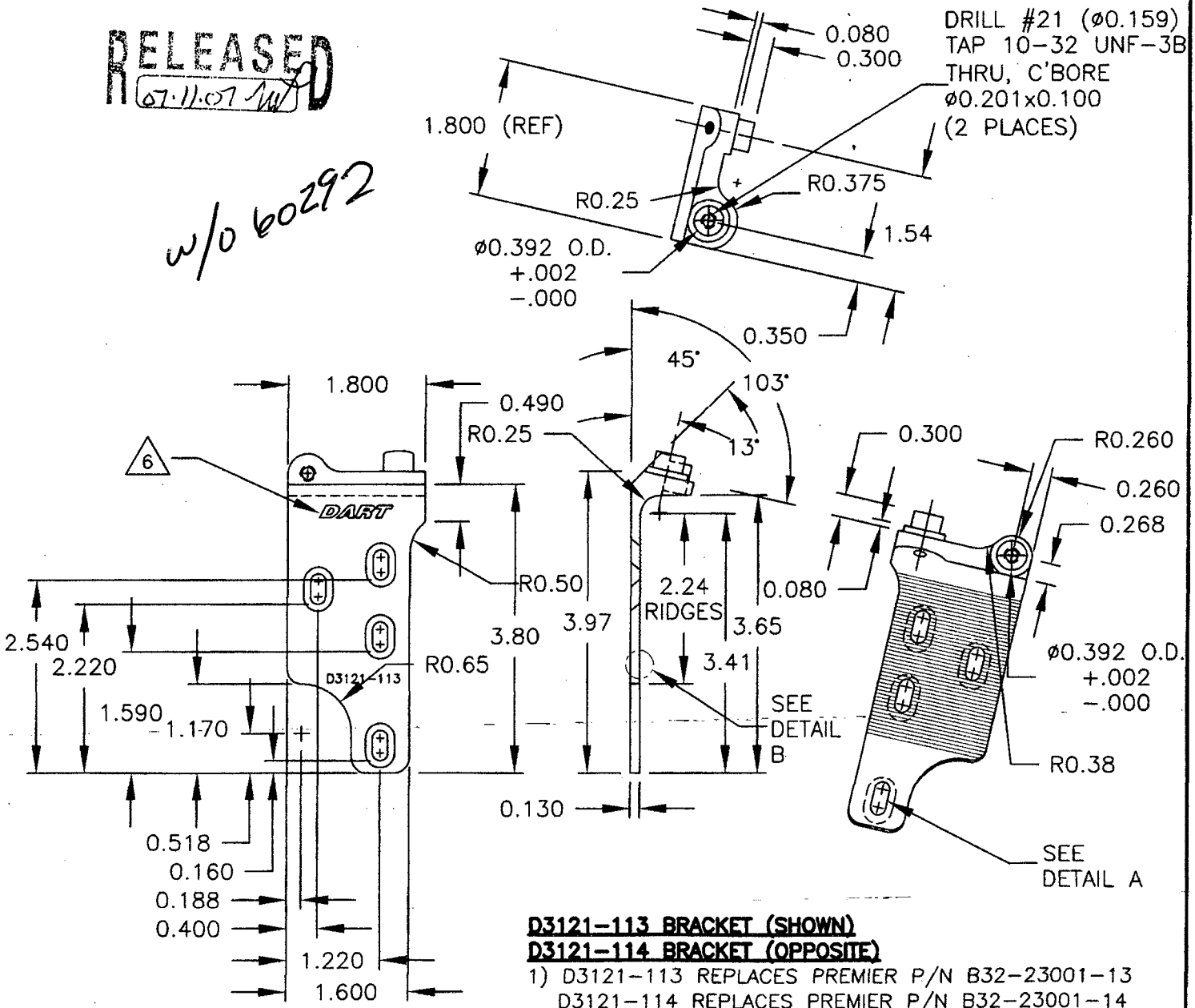
DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. E SHEET 8 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED 07.11.07

w/o 60292



D3121-113 BRACKET (SHOWN)
D3121-114 BRACKET (OPPOSITE)

1) D3121-113 REPLACES PREMIER P/N B32-23001-13
   D3121-114 REPLACES PREMIER P/N B32-23001-14
2) MATERIAL: 17-4 SS PER AMS 5604/5643
   (REF DART SPEC. M17-4-B)
   MIN ULTIMATE TENSILE STRENGTH = 150 ksi
   MIN YIELD TENSILE STRENGTH = 100 ksi
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015
6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005